

Date: Friday, 27/02/2009 10:35:50 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE, INBOARD, LS, 206
<b>Job Number</b> : 46099	
<b>Estimate Number</b> : 10820	
<b>P.O. Number</b> :	<b>Part Number</b> : D26661
<b>This Issue</b> : 27/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2666 REV. D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 44284	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/03/2009 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 090207</u>	
<b>Comment</b> : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

Saddle Billet

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: 46409

DJP  
 09/04/13

(8)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

1- Inspect part number and batch number are programmed correctly.

2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

J-F. 09/04/14 (8)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE

**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J-F. 09/04/14 (8)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 09/04/14 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries.

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User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 46099

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 09/04/15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ML 09 04 15

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 09 04 15

(8)

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

BL 09-04-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 09/04/20 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 426

CL 9/4/21 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (8)

Job Completion



ML 09-04-21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> H6099	
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2666-1	
<b>Inspection Dwg:</b> D2666 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.122	.122		
B	0.100	0.140		.120	.120	.120	.121		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.220	.218	.219	.219		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.249	.247	.247	.247		
H	0.615	0.685		.645	.645	.645	.645		
I	1.125	1.145		R1.136	R1.136	R1.137	R1.137		
J	0.990	1.010		1.007	1.007	1.007	1.007		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.115	.115	.115	.115		
N	1.565	1.585		R1.578	R1.578	R1.579	R1.579		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.502	.503	.502		
S	0.313	0.318		Ø.313	Ø.313	Ø.313	Ø.313		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.315	0.322		Ø.320	Ø.320	Ø.320	Ø.320		
W	0.540	0.560		.550	.552	.551	.551		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		Ø.259	Ø.259	Ø.259	Ø.259		
Z	0.178	0.198		R.188	R.188	R.188	R.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	09/04/14

Audited by:	J.L.
Date:	09/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.220	.220	.218	.219		
F	1.313	1.343		1.322	1.322	1.322	1.322		
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H	0.615	0.685		.645	.645	.645	.645		
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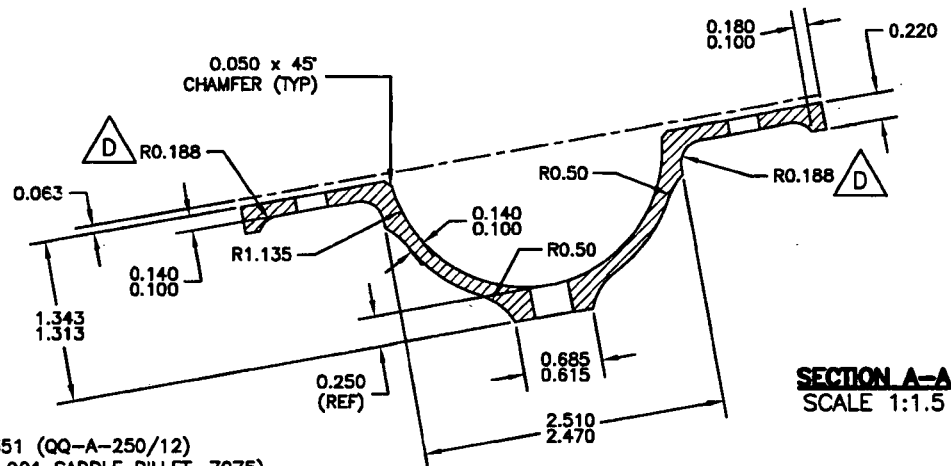


**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

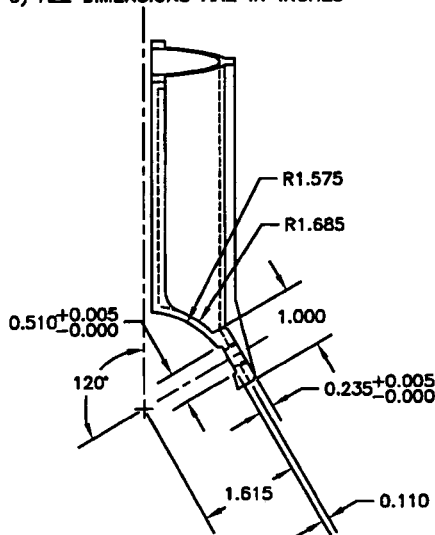
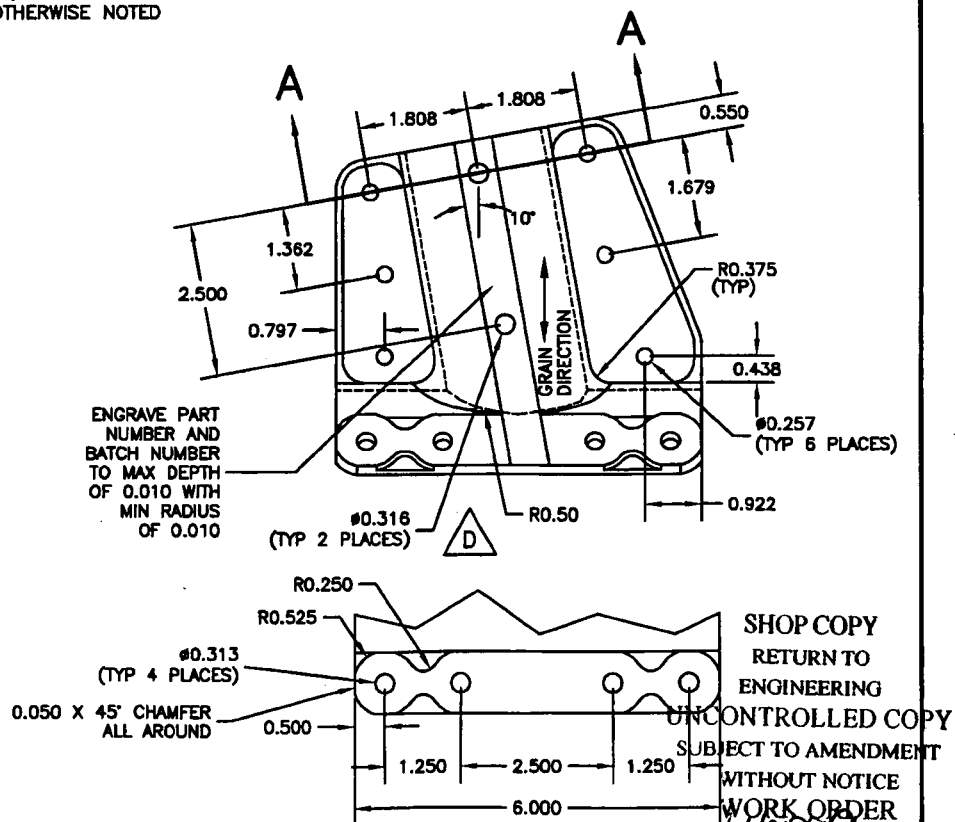
RELEASED

07-02-12 [Signature]



## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 410099

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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